

er ID 68553

11/15, 2011 12:41:19 PM



Page 1

ID: D350-748-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 11-04-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-748-241	F

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPPD350-748-201

CHG002

S u l o b / r o

H d r M L S 11-10-25

110



CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

0.00

Memo

0.00

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

DP

11-8-30

120



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

S u l o b / r o

Dart Aerospace Ltd

W/O: 68553


WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 350-748-201 PAR #: N/A Fault Category: X-tube NCR: Yes No Yes DQA: Yes Date: 11.10.28
 Resolution: use - as-is Disposition: use - as-is QA: N/C Closed: Yes Date: 11/10/31

NCR: 11-937

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.08.30	110	one side bent too high. Re: process	CP 11.08.31 DS/04/2	Cut high side too 31.60". Re-measure. = Acceptable	 11-8-31	JW 11-08-31	CP 11.08.31 DS/04/2	S 11.08.31

NOTE: Date & initial all entries

Work Order ID 68553

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Page 2

Item ID: D350-748-201

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Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
HandFXtube		0.00							
Hand Finishing Crosstubes	Memo ***Stress relief*** Heat treat crosstube as per QSI010 4.3 Temp: <u>375</u> Start time: <u>4h30</u> Finish time: <u>8h30</u>								
			SAD	11-08-30					
127	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control				8 w/06/31					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68553

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Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241

5- Apply a light coat of LPS3 on the interior of tube
Batch: M109956

SAD

11-09-07

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S w o r l o r

④

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	Outsource process-Cadplate per QSI017 4.1.9.1	0.00							
-----	---	------	--	--	--	--	--	--	--



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 14834
Stress relief at 375° for 5 hours
Magnetic Particle Inspect per ASTM E1444
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2
Embrittle relief at 375° for 8 hours, Chromate Treat
Possible Supplier: Southwest United Industries
Ensure Certificate of Conformity is attached

CL 11/09/06 ①

160	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

★ SEE W/O CHG ATTACHED

Paul 11/11/11 ①
Paul 11/14/11

170	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC

Memo

0.00

Quality Control

11 10 17 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O: 68553

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.10.13	161	LOAD TUBE TO 3000 ^{lb} FOR 1 MINUTE REF D.S. EMAIL	CP	11.10.14	1	CP 11.10.14 B1642	S 11/10/28
11.10.13	162	NDT TUBE PO 15157	H	11/10/14	1	h	S 11/10/28

Part No: D350-748-201 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Tuesday, April 27, 2010 3:40 PM
To: 'Mike Petsche'
Cc: 'Bill Beckett'; 'L Lacelle'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com
Subject: 350 crosstubes

Mike,

I discussed the 350 crosstube load testing with Bill a little while ago and this plan makes sense to him.

So, my recommendation to clear these crosstubes is to load the fwd crosstubes to 3500 lb and the aft crosstubes to 3000 lb in the deflection test rig and document on the work orders that this test has been completed. Hold max load for 1 minute. Per TP-D350-748-2, these loads represent the maximum load on these crosstubes at gross weight and are below the yield point of the material. I would like to request that Chris Provencal witness these tests and sign off the work orders based on his experience with Dart landing gears. My feeling is that if there is a problem with the parts, it will manifest itself during this load test. I, for one, would feel a lot more confident in testing each crosstube in this manner than relying totally on what Exova has to say. I think it would be very difficult to reach a conclusion on the whole batch on the basis of cracks in two parts from the batch.

I believe that we can accomplish this before next Friday, which also gives us time to hear what Exova has to say in case it has an impact on our decision. So far, what I have seen from Exova shows me that there are fluctuations in the heat treating but the tubes are heat treated to our specification.

For this reason, I believe we should tell DHS that it looks like we will be able to start shipping 350 crosstubes by May 7th pending a successful Engineering test of the material.

David.

Work Order ID 68553

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Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2								
190		0.00							
	QC14- Inspect Spray Paint								
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200		0.00							
	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abraison strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								

11-10-20

11/10/21 (1)

11-10-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							<i>m/ 11 / 10 / 25 ①</i>
220 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							<i>11/10/26</i>
230 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							<i>Schloke</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 68553

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Item ID: D350-748-201

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Setup Start



Revision ID:

Stop



Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPPD350-748-201								
	Location: <u>B</u>								
	PPP Rev: <u>B</u>								
250	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

11/10/24

11/10/28

ME
11-10-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 68553



Parent Item: D350-748-201



Parent Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 06-07-05 JLM
 IPP Rev: B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev C Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:D 08-06-24 revD as per dwg DD verified by:EC
 IPP Rev: E 08.12.11 Step17 was step 21 KJ Verified by:EC IPP Rev:F
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225 		Purchased	No			200	Each	1,113.000	1	1			
Insert													

118696



25 11-10-24

Location

Loc Qty

Loc Code

FP-B

40

110768

40

ST282

1073

110768

1073

AN4-41A-

Purchased

No

220

Each

198.0000

8

8



Bolt



11/10/2011

Location

Loc Qty

Loc Code

ST360

198

115108

98

115705

50

116191

50

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 68553

Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-6A

Purchased

No

220

Each

1,071.000

16

16

Bolt

Location

Loc Qty

Loc Code

ST356

1071

115936

200

116191

71

116400

400

116924

400

AN5-32A

Purchased

No

220

Each

137.0000

4

4

Bolt

Location

Loc Qty

Loc Code

ST340

137

115108

27

115589

60

117161

50

AN960JD10

NAS1149D0363J

Purchased

No

200

Each

0.0000

1

1

Washer

AN960JD416

NAS1149D0463J

Purchased

No

220

Each

0.0000

32

32

Washer

AN960JD516

NAS1149D0563J

Purchased

No

220

Each

0.0000

8

8

Washer

Friday, April 15, 2011 12:41:15 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured No

200 f

231.0696

1.181

1.243158



Abraison Strip

71164



25 11-10-24

Location

Loc Qty

Loc Code

ST403

216

68076

216

ST409

15.0696

63735

15.0696

1- cut as per dwg D2856

D3500-1

Manufactured No

220

Each

44.0000



Saddle



4 4 B68947 S

Location

Loc Qty

Loc Code

ST424

9

66127

9

ST424/25

20

62207

20

ST425

15

61838

15

D3501-1

Manufactured No

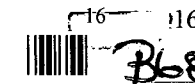
220

Each

67.0000



Bushing



16 16 B68939 11/10/24

Location

Loc Qty

Loc Code

ST063

67

61984

67

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3502-1
Support
Manufactured No

200 Each

31.0000

2

2

68951 x 1



25 11-00-24

Location

Loc Qty

Loc Code

ST063

31

61206

12

61843

9

64004

10

21

D350-748-241TRN
Crosstube Turning Detail
Manufactured No

110 Each

2.0000

1

1



Location

Loc Qty

Loc Code

LG046

2

64476

1

64890

1

MS21042L4
Nut
Purchased No

220 Each

2,582.000

24

24



1117441

Location

Loc Qty

Loc Code

ST300

2582

116188

582

116823

2000

MS21042L5
Nut
Purchased No

220 Each

761.0000

4

4



1117441

11/10/26

Location

Loc Qty

Loc Code

ST300

761

115594

1

116105

500

116548

260

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 4/18/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased

No

200

Each

72.0000

2

2



Clamp (per MIL-DTL-8783C)

118649



11-10-24

Location

Loc Qty

Loc Code

LG050

72

116799

22

117279

50

MS27039-1-10

Purchased

No

200

Each

67.0000

1

1



Screw

118612



11-10-24

Location

Loc Qty

Loc Code

ST291

67

115935

67

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

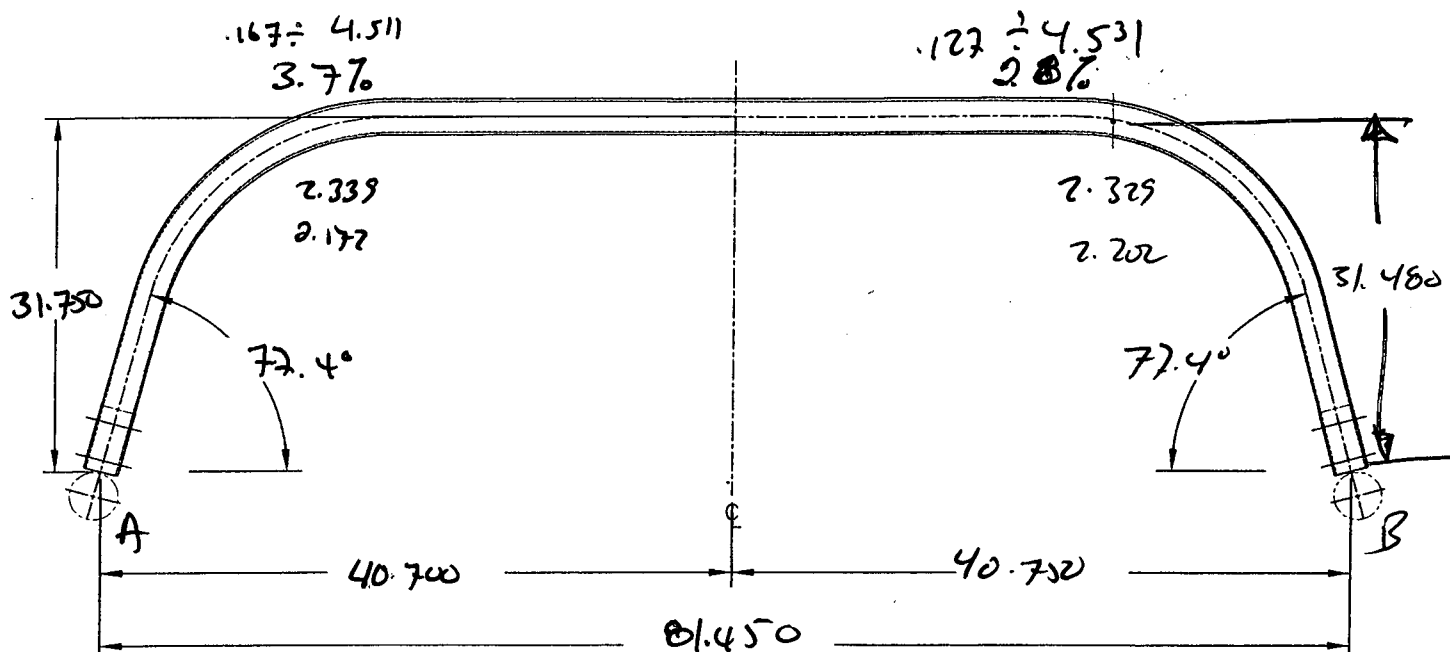
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68553
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



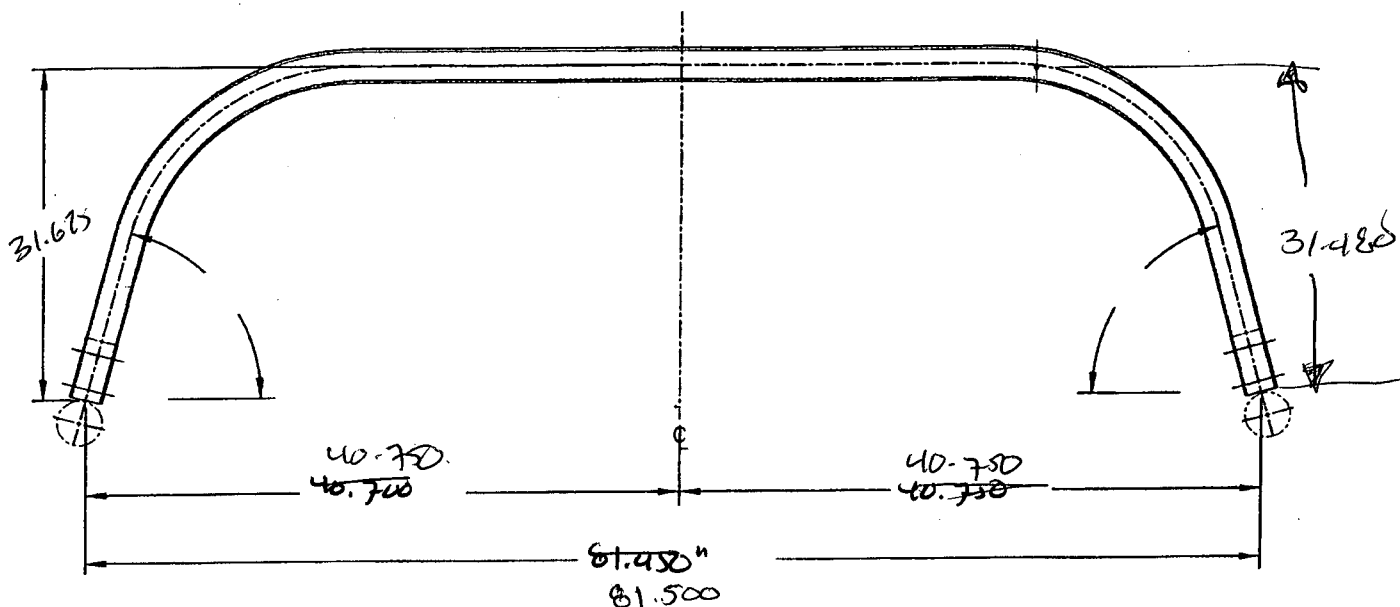
Comments
twist $\approx 0.096^\circ$
Side A $\approx 3.7\%$ crushy @ 7 passes
Side B $\approx 2.8\%$ crushy @ 7 passes

QC15 Inspection	S
Date	4/02/31

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Aft (AS350/355)		Part Number:	D350-748-201
Inspection Dwg: D350-748-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
twist = 0.038"
Acceptable of 11.08.31 18104

QC15 Inspection	8
Date	11/08/31

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

750
750
500

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6015-125	CROSSTUBE (OR D6018-125)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING
LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER
BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

RELEASED
R 2011-01-08

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-748-241	REV. F SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
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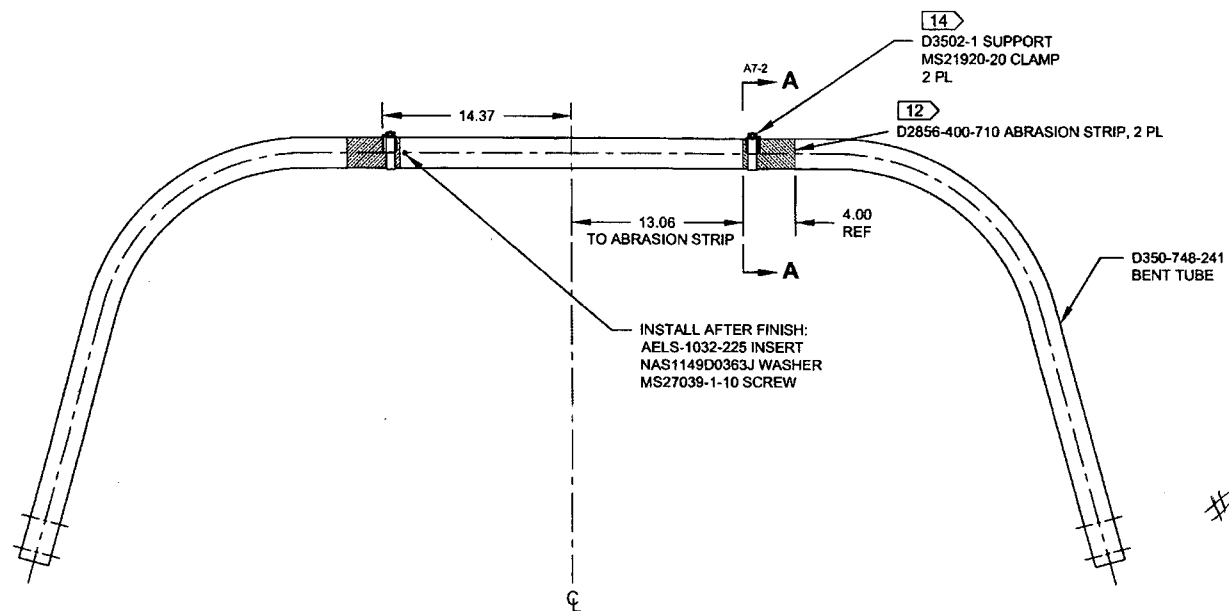
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

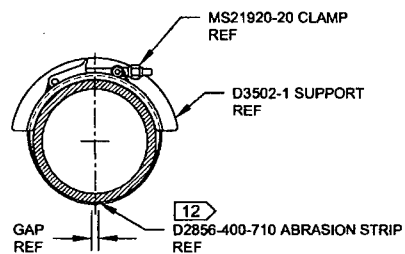
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#68553

**D350-748-241
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 4X

RELEASED
2011-03-18
JMT

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	9P	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. F
MFG. APPR.	13	D350-748-241	SHEET 2 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

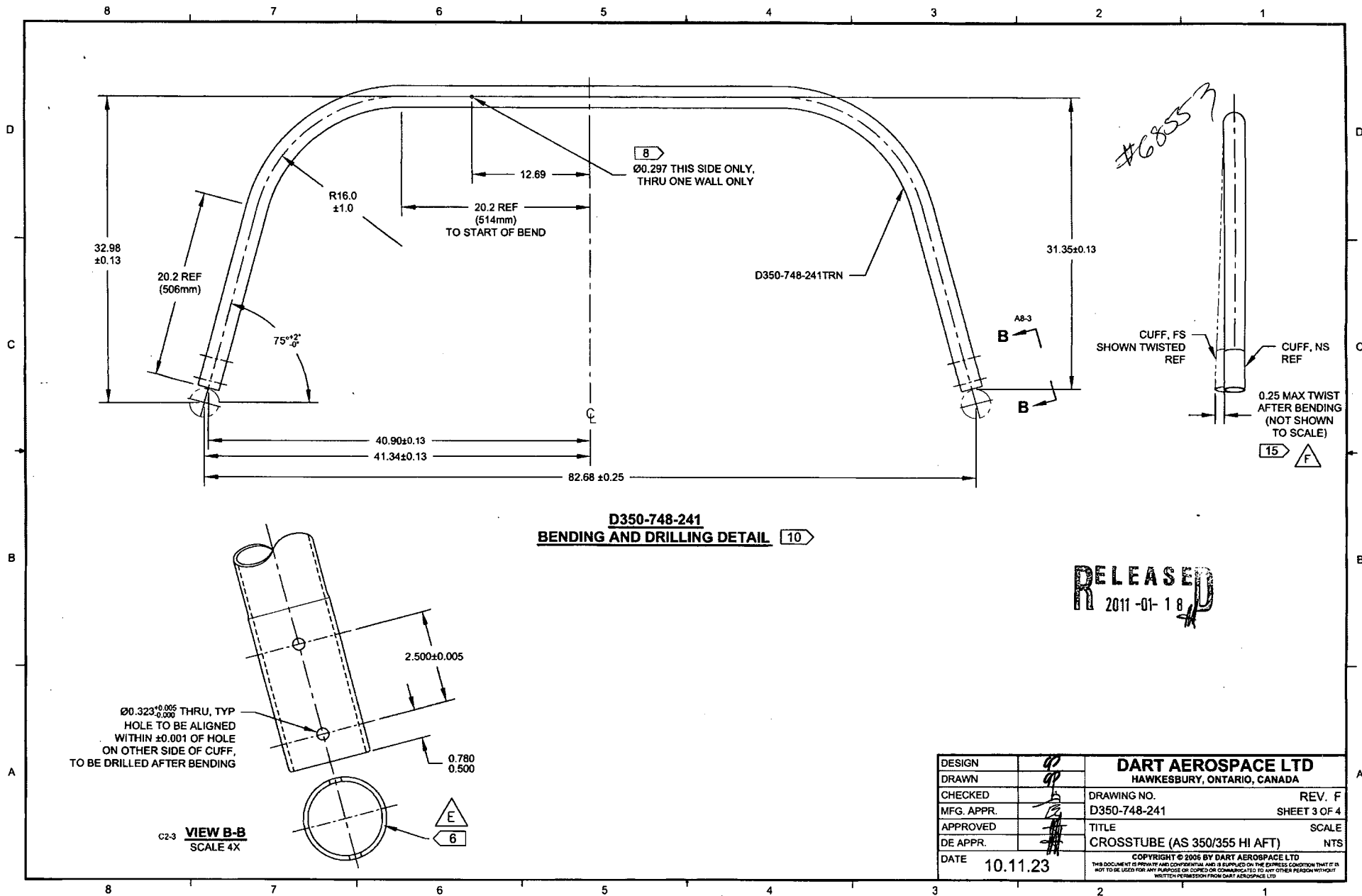
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-748-241
BENDING AND DRILLING DETAIL 10

RELEASED
 2011-01-18

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. F
MFG. APPR.	2	D350-748-241	SHEET 3 OF 4
APPROVED	11	TITLE	SCALE
DE APPR.	11	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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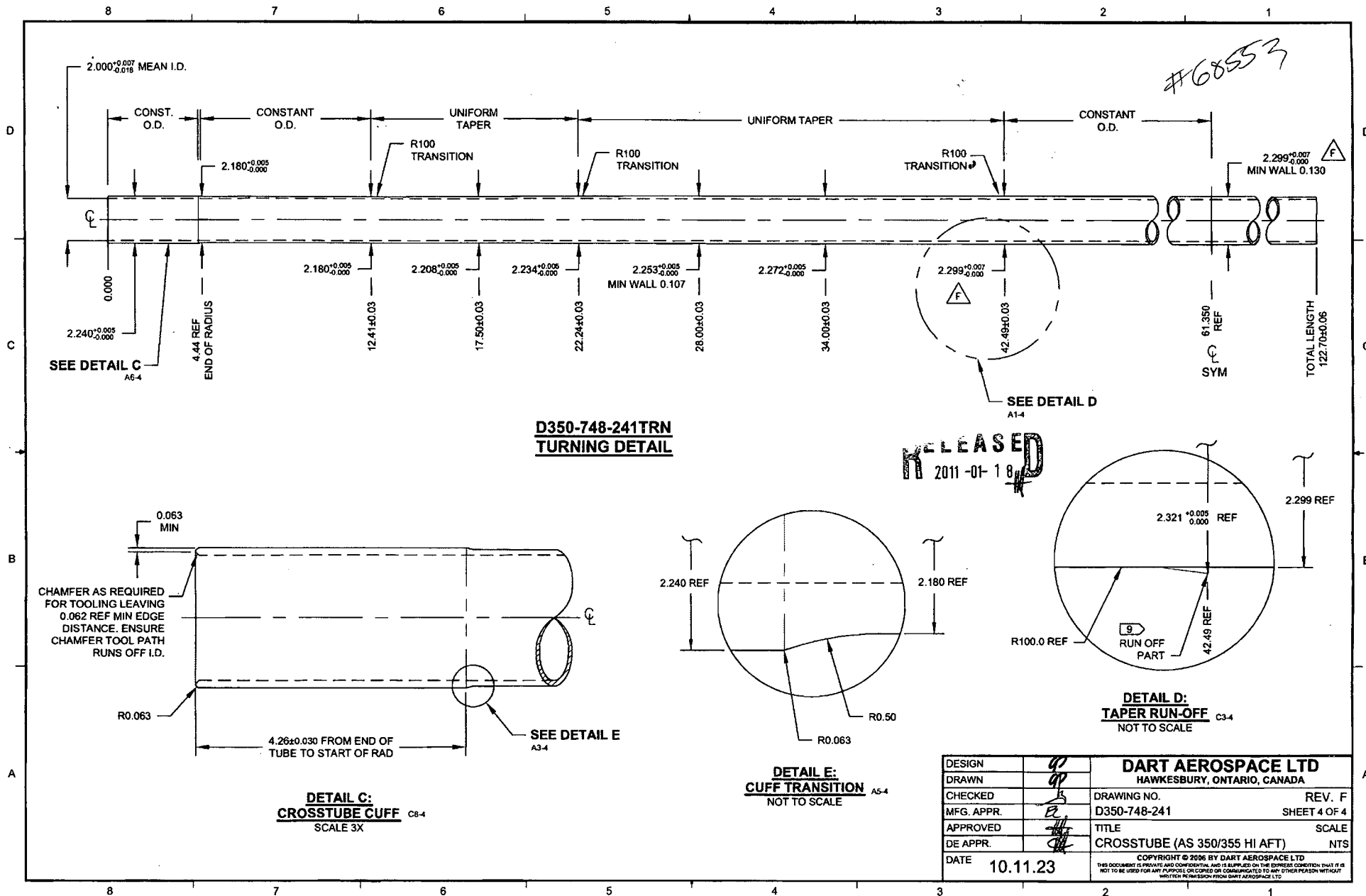
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

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Revision: **B**

Date: 07.06.15

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Sep-30-2011

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 107801
INVOICE #: 56968

**CONTRACT OR
PURCHASE ORDER #** 14834

DESCRIPTION: SKID

QTY 1

P/N # D350-748-201

S/N # B68553

STRESS RELIEF BAKE HEAT CHART # 11-1001. MPI IAW ASTM -E-
1444. CADMIUM PLATE IAW AMS-QQ-P-416 C TYPE 2 YELLOW
CLASS 1. BAKE HEAT CHART # 11-1027.

CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.

Approved Inspector: _____





LIQUID PENETRANT TEST REPORT

P- 05635

CLIENT DART AEROSPACE DATE OCT-14-2011 PAGE 1 OF 1
ATTENTION LINDA / CHANTALE / IAN / MATT ACUREN JOB No. _____
ADDRESS 1270 ABERDEEN ST. PO/NO No. 14834
HAWKESBURY ON WORK LOCATION _____
PROJECT PT-D WET FLUORESCENT LIQUID PENETRANT ON "CROSSTUBES" ACCEPTANCE STD. _____ REV./DATE _____
ITEM(S) EXAMINED - SEE BELOW

JOB DESCRIPTION _____ PROCEDURE No. LT 002 REV./DATE 2007 TECHNIQUE No. LT 002 REV./DATE 2007
PART No. _____ MATERIAL STEEL THICKNESS N/A
SCOPE PERFORMED A WET FLUORESCENT LIQUID PENETRANT INSPECTION ON 100% OF THE EXTERNAL SURFACE ON THE ITEMS MENTIONED BELOW

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☐ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 13798 OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2L-67 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER A20 MINIMUM DRY TIME > 10 MIN. OTHER _____
DEVELOPER SKD-39 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE Aug/2012
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT-BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

1 CROSSWBE W.O. ID 68549 ✓
2 68550 ✓
3 68551 ✓
4 68553 ✓
5 72004 ✓
6 72005 ✓
7 73364 ✓

ITEM ID D350-748-201 HIGH AFT
D350-748-201 HIGH AFT
D350-748-201 HIGH AFT
D350-748-201 HIGH AFT
D350-748-201 HIGH AFT
D350-748-201 HIGH AFT
D350-748-201 HIGH AFT

NO RELEVANT INDICATION WAS DETECTED
AS PER APPLICABLE STANDARDS.

11-10-17

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Ian Tittley DTR # E44763
TECHNICIAN (SIGNATURE): [Signature] SIGNATURE
NAME (PRINT): IVES DESROSIERS REPORT REVIEWED BY: _____
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL 2 SNT LEVEL 2
CGSB REG. NO. 3099 CGSB REG. NO. _____

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